



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G15231-3G

Job Sheet 173109



Part No: RBW6205G15231-3G

Job Qty: 1 ea

Part Name: AW139 Swashplate Kit Box 1



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G15231-3G REV 1 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/9/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs		3/9/18	0.00	0.00	Small Fab-4		MLC DAS 38
120	QC	1 pcs		3/9/18	0.00	0.00	QC5		9-89
130	Packaging	1 pcs		3/9/18	0.00	0.00	Packaging3-1		MAY 17 2018
140	QC21-FG	1 Ea		3/9/18	0.00	0.00	QC21		DAS

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican Strom
Descriptions: case IM-2875-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6205G15231-3G-9 to RBW6205G15231-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90183A213 CA	BLIND RIVET FLAT WASHER ALUMINUM, ROUND, FOR 1/8" RIVET BODY DIA., 3/8" OD	4 Ea (4 ea)	90-Start up Operation	5058735
4611T26 86	Cup	2 Ea (2 ea)	110-Small Fab	5051220
97447A130 CA	Aluminum Blind Rivet W/Aluminum Mandrel Domed, 1/8" Dia., 0.313"-0.375" Material Thickness	4 Ea (4 ea)	110-Small Fab	5054330
AN5-10A 4337	Bolt	8 Ea (8 ea)	110-Small Fab	5017095
AN5-27A 4337	Bolt 5/16 X 2 31/32 Steel	4 Ea (4 ea)	110-Small Fab	5048291
AN960-516 51322	WASHER	8 pcs (8 ea)	110-Small Fab	5041158
IM2875-E CA	Pelican Case	1 (1 ea)	110-Small Fab	5018596
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5021040
95 RBW6205G11451-3G	Clamp	8 Ea (8 ea)	110-Small Fab	5065155
CA RBW6205G11651-3G	Guide	1 Ea (1 ea)	110-Small Fab	5058371
CA RBW6205G11751-3G	Guide	1 Ea (1 ea)	110-Small Fab	5063264
RBW6205G15231-3G-5 Bottom Foam		1 (1 ea)	110-Small Fab	5068597
RBW6205G15231-3G-7 Lid Foam		1 (1 ea)	110-Small Fab	5068598
94 RBW6205G15231-3G-9 Inside Placard		1 Ea (1 ea)	110-Small Fab	5070507
95 RBW6205G15551-3G Pin		1 Ea (1 ea)	110-Small Fab	5062834

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90183A213	4	0	0
110-Small Fab	4611T26	2	0	0
	97447A130	4	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid- ☐ Mach ☐ Thermofo ☐ Large ☐		ering ☐ ality ☐)ther ☐
Date : _____		Step #: _____		QTY _____		2) Approval
Description Work Order Deviation						ted By
						Supervisor rification
						ordinator val
Root Cause						Wrong nensions r tolerance ect fissing I
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Date: 05/16/18 Inspector: _____ Revision: 1 Serial No/Batch: S071716 Job No: 173109 Part: RBW6205G15231 - 3G Container No: S071716 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Misaligned/off center ☐ Turning Sequence ☐
Design	☐	Operator	☐	Bending	☐	
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	
Equip/Tooling	☐	Supplier	☐	Cracks	☐	
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	
Material	☐	Use for Testing	☐	Cuffs	☐	
Internal Transport	☐	Poor Information	☐	Crushing	☐	
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	
Past Expiry Date	☐	Manufacturing Process	☐	Drill Holes	☐	
Misidentified	☐	Past Due	☐	OTHER : _____		

AN5-10A	8	195	0
AN5-27A	4	0	0
AN960-516	8	300	0
IM2875-E	1	0	0
RB41011	1	944	0
RBW6205G11451-3G	8	0	0
RBW6205G11651-3G	1	0	0
RBW6205G11751-3G	1	0	0
RBW6205G15231-3G-5	1	0	0
RBW6205G15231-3G-7	1	0	0
RBW6205G15231-3G-9	1	0	0
RBW6205G15551-3G	1	0	0

Part Specifications

Specifications could not be found.

Plex 2/26/18 10:58 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

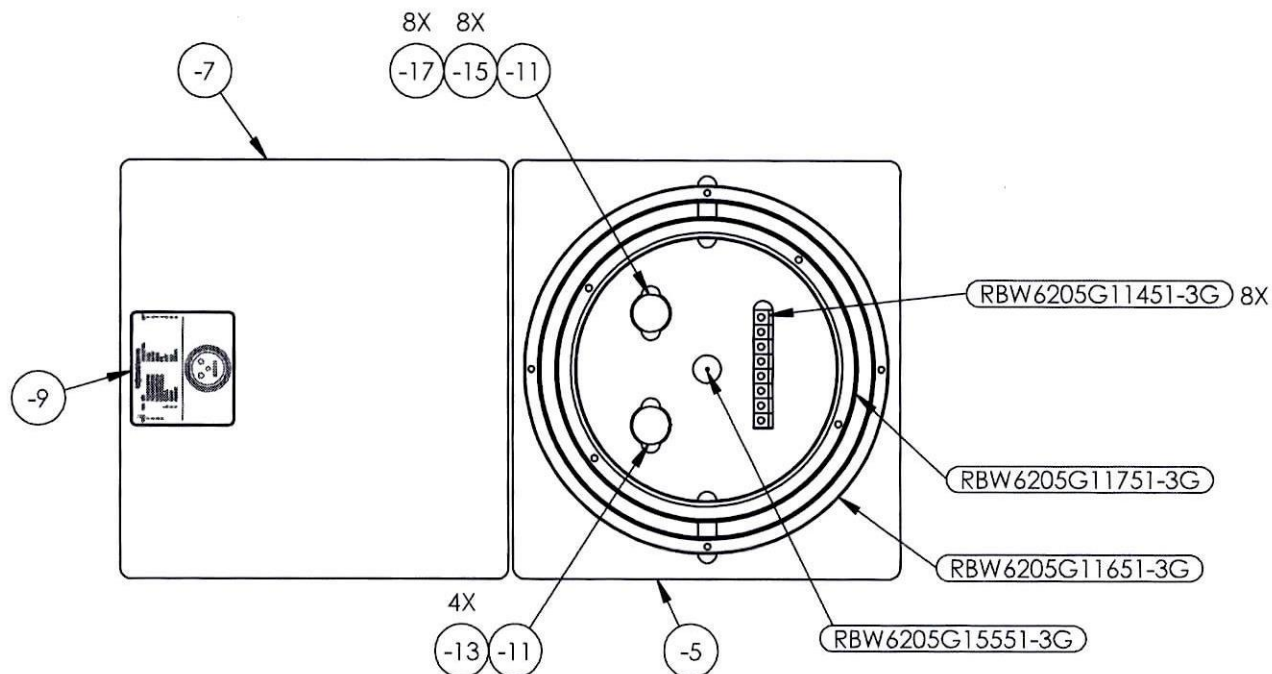
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-5 ADDED FINGER CUTOUTS. -7 CH'D PLACARD CUTOUT TO RECESSED, CH'D MATERIAL WAS EGGSHELL IS C200 FLAT.	5/24/2011	RJC	RW
1	15-0175	-7 CH'D MATERIAL WAS C200 FLAT IS Y20 BLACK. -9 DELETED CONTENT LIST FROM PLACARD. -19, -21, & -23 ADDED TO BOM.	7/17/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173105 MLJ

1802-26

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GUIDE		RBW6205G11651-3G	1
				8	CLAMP		RBW6205G11451-3G	1
				1	GUIDE		RBW6205G11751-3G	1
				1	PIN	W1 TOOL STEEL	RBW6205G15551-3G	1
		B/O	-3	1	CASE	PLASTIC, BLACK	11.40 X 21.10 X 22.50 PELICAN STORM IM2875-E	N/S
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	9-1/2 X 21 X 22-1/2 IR SPECIALTY FOAM	2
		B/O	-7	1	LID FOAM	Y20 BLACK	2 X 21 X 22-1/2 IR SPECIALTY FOAM	3
			-9	1	INSIDE PLACARD	PLASTIC		4
		B/O	-11	2	CUP	CLEAR PLOYSTYRENE	Ø1.77 X 4.02 (MCMaster-CARR #4611T26)	1
		B/O	-13	4	BOLT	STEEL	AN5-27A	1
		B/O	-15	8	BOLT	STEEL	AN5-10A	1
		B/O	-17	8	WASHER	ALUMINUM	AN960-516	NS
		B/O	-19	1	DART PLACARD	ALUMINUM	#RB41011	N/S
		B/O	-21	4	RIVET	ALUMINUM	Ø1/8 X .525 (MCMaster-CARR #97447A130)	N/S
		B/O	-23	4	BLIND RIVET WASHER	ALUMINUM	Ø1/8 (MCMaster-CARR #90183A213)	N/S

NOTE:
REF. AGUSTA T/N: 3G6205G15231.
PART OF KIT RBW6205G11231-3G.

DART AEROSPACE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G15231-3G	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE 1:10 DATE 1/31/2011 SHEET 1 OF 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					